



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5738-045
Job Sheet 203349

Accounting Job RD19-1069-01



POSITIVE RECALL

EFFECTIVE 10/1/19 AUTH *ne*

RELEASED 9-89 DATE 12.11.18

Part No: D5738-045

Job Qty: 2 pcs

Part Name: AFT Wearbar Assembly



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Priority: Medium

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5738 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Welded Assy-1	2 pcs	11/29/19		0.00	0.08	Large Fab - 1		<i>ne</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Automated Welding - B4B	2 pcs	11/29/19		0.00	1.56	Automated Welding - 1 - B4B		<i>MS</i>
120	QC 10	2 pcs	11/29/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		<i>ne</i>
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
130	QC 5	2	11/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		



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Container No: S235047



Part: D5738-045

Job No: 203349

Serial No/Batch: S235047

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/26/19

Plex 11/15/19 11:11 AM Dart.lajeunesse.marie

				QC 5 - 49					
				QC 5 - 51					
				QC 5 - 58					
				QC 5 - 68					
				QC 5 - 9					
				QC 5 - 50	2				
				QC 5 - 30					
				QC 5 - 40					
				QC 5 - 61					
				QC 5 - 81					
				140 Packaging 3-1 - Stock - B4B	2 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
								Packaging 3 - 2 - B4B	
								Packaging 3 - 3 - B4B	
								Packaging 3 - 4 - B4B	
Packaging 3 - 5 - B4B									
Packaging 3 - 6 - B4B									
Packaging 3 - 7 - B4B									
Packaging 3 - 8 - B4B									
Packaging 3 - 9 - B4B									
Packaging 3 - 10 - B4B									
Packaging 3 - 11 - B4B									
Packaging 3 - 12 - B4B	2								
Packaging 3 - 13 - B4B									
Packaging 3 - 14 - B4B									
Packaging 3 - 15 - B4B									
Packaging 3 - 16 - B4B									
Packaging 3 - 17 - B4B									
Packaging 3 - 18 - B4B									
Packaging 3 - 19 - B4B									
Packaging 3 - 20 - B4B									
Packaging 3 - 21 - B4B									
Packaging 3 - 22 - B4B									
Packaging 3 - 23 - B4B									
Packaging 3 - 24 - B4B									
Packaging 3 - 25 - B4B									
Packaging 3 - 26 - B4B									
Packaging 3 - 27 - B4B									
Packaging 3 - 28 - B4B									
Packaging 3 - 29 - B4B									
Packaging 3 - 30 - B4B									
Packaging 3 - 31 - B4B									
Packaging 3 - 32 - B4B									
Packaging 3 - 33 - B4B									
Packaging 3 - 34 - B4B									
Packaging 3 - 35 - B4B									
Packaging 3 - 36 - B4B									
150 QC 21 - SA	2 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21					
				QC 21 - SA - 70					
				QC 21 - SA - 53					

POSITIVE
RECALL

DAS
9
9-89

12.11.28

DAS
21
9-89

NOV 29 2019



DAS 12.11.20
9
9-89

DAS
21
9-89

NOV 29 2019

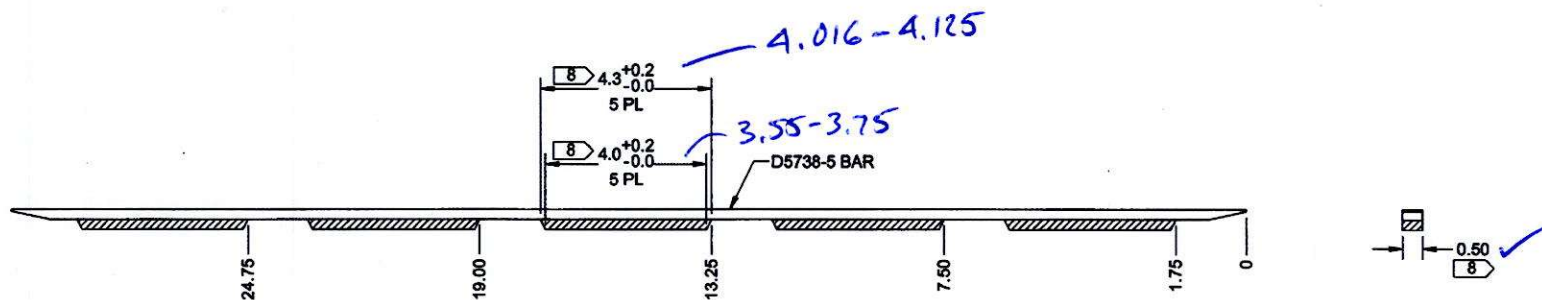
Part Op 100 - (Large Fab) Cut D5738-5 at 32.10" (EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D5738-045)
 Descriptions: 110 - (Automated welding) 1-USE GRINDER TO CHAMFER END AS PER DWG. ***SEE NOTE 8 FOR SURFACE BUILDUP*** USE DT WELDING FIXTURE 8259-M139025
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: W/A001) LOCATION: WA002
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304B0.250x0.500	304 Bar .250 X .500	5.3600 ft (2.68 ea)	100-Large Fab - Welded Assy-1	52 27407

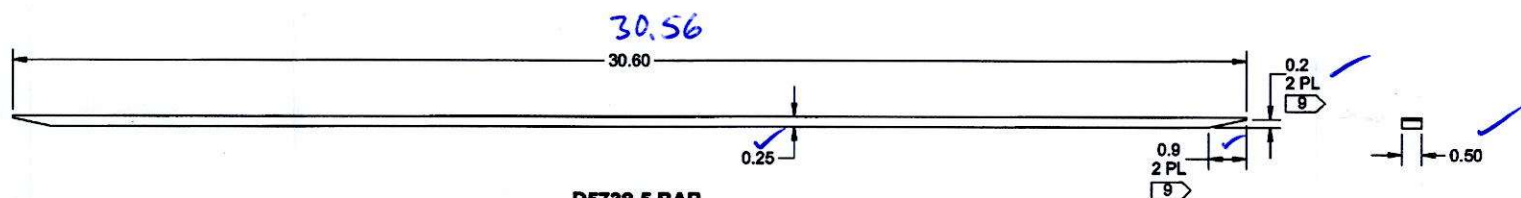
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.250x0.500	5	618	0

Part Specifications
Specifications could not be found.

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D5738-045 AFT WEARBAR ASSY



D5738-5 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

UNDER REVIEW

URF 19-1208 19.11.07 (VM)

NOTES:

1) MATERIAL: MAKE D5738-5 FROM AISI 304/316 SS BAR, 0.25 THICK X 0.50 WIDE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.80 lbs

8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER DART QSI 004 4.1 (AUTOMATED WELDING) OR

BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER DART QSI 004 4.1 (MANUAL WELDING)

9) GRIND CHAMFER 0.9 X 0.2

APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5738	SHEET 3 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	WEARBARS	NTS
DATE	19.08.23	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

203349 MW
19-11-15

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>203349</u> Part No. <u>D5738-045</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date: <u>19.12.11</u>	Sequence #: <u>130</u>	QTY Affected: _____		MRB (QSI042)
Description Work Order Deviation weld size is under tolerance dwg 4.3 ± 0.200 is 4.016 dwg 4.0 ± 0.200 is 3.55		Disposition welds acceptable as is dwg tolerances will be revised to match achievable manufacturing tolerance		NO 19.12.11 Completed By NO.19.12.11 Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
		Other/Details: _____		

